

DART
AEROSPACE
S014140

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Aft Beam

PART NO: D4276-1

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/27/17

Job No: 167899



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D4276-1
Job Sheet 167899



Part No: D4276-1

Job Qty: 1 ea

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/7/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: SOLD ✓

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV.A DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/17	12/7/17	0.00	0.00	Start Up Machining	mm	
100	Bandsaw	1 pcs	12/7/17	12/7/17	0.00	0.02	Bandsaw1	mm	
110	CNC Vertical Machining	1 pcs	12/7/17	12/7/17	0.58	1.79	HAAS 1	mm	
120	QC	1 pcs	12/7/17	12/7/17	0.00	0.00	QC2	mm	
130	QC	1 pcs	12/7/17	12/7/17	0.00	0.00	QC8	mm	
140	HandFinish	1 pcs	12/7/17	12/7/17	0.00	0.12	HandFinish1	mm	
145	Powdercoat	1 pcs	12/8/17	12/8/17	0.00	0.09	Powdercoat1	mm	
150	QC	1 pcs	12/8/17	12/8/17	0.00	0.00	QC3	mm	
180	Packaging	1 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3	mm	
190	QC21-SA	1 Ea	12/8/17	12/8/17	0.00	0.00	QC21	mm	

Part Op 100 - Cut Blank to 36.630"

Descriptions: 110 - 1-Machine per folio FB007

145 - MASK AS PER DWG

138467 START: 10:10 OUT: 3:20 FINISH: 10:40

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X04.000	3	22	0	0

Part Specifications

Specifications could not be found.

137960

304139

Plex 11/27/17 8:50 AM dart.poulin.mario

DART AEROSPACE LTD		Work Order:	167899
Description: Aft Beam		Part Number:	D4276-1
Inspection Dwg: D4276 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.751	✓		high gage	
20.500	+/-0.010	20.500	✓		Dans machine	
Ø0.381	+0.000/-0.001	.3805	✓		Pin gage	
14.380	+/-0.010	14.376	✓		high gage	
R0.75	+/-0.030	R.750	✓		Boberit	
3.50	+/-0.030	3.502	✓		Vernier	
16.38	+/-0.030	16.372	✓		high gage	
5.00	+/-0.030	5.000	✓		Vernier	
0.75	+/-0.030	.751	✓		Vernier	
2.75	+/-0.030	2.751	✓		Vernier	
3.00	+/-0.030	3.002	✓		Vernier	
1.250	+/-0.010	1.250	✓		Vernier	
4.50	+/-0.030	4.508	✓		Vernier	
0.734	+/-0.010	.731	✓		micrometer	
0.108	+/-0.010	.107	✓		high gage	
36.38	+/-0.030	36.380	✓		tape	
0.95	+/-0.030	.949	✓		high gage	
0.60	+/-0.030	.600	✓		Vernier	
2.70	+/-0.030	2.697	✓		Vernier	
1.10	+/-0.030	1.100	✓		Vernier	
1.25	+/-0.030	1.2505	✓		high gage	
0.75	+/-0.030	.751	✓		Vernier	
3.000	+/-0.010	2.999	✓		Vernier	
1.500	+/-0.010	R.1500	✓		Boberit	
Ø0.191	+0.005/-0.001	.1968	✓		Pin gage	
2.300	+/-0.010	2.301	✓		Vernier	
3.50	+/-0.030	3.502	✓		Vernier	
R0.60	+/-0.030	R.060	✓		Boberit	
1.70	+/-0.030	1.700	✓		Vernier	
0.65	+/-0.030	.652	✓		Vernier	

Measured by:	MM. my
Date:	

Audited by:	FK
Date:	17-12-4

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ	MM